

Work Order ID 144614

Thursday, April 28, 2016 10:05:24 AM

144614

Page 1

Item ID: D4125-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Sediment Bowl

Start Date: 4/27/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/9/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4125	D
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100	0.00
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100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut Blank at 13.375"

DAS
44
9-89

16-07-29

105

0.76

105

HAAS 1

Memo

4.05

HAAS CNC vertical machine #1

Machined as per folio FB078

Rev: AADwg: D

Deburr

5

1

SN 1673
16-07-29

DQA:

Date: 09/22/2016



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 08 0 2016

Work Order update only ☐

Work Order: <u>144614</u> Part No. <u>D4125-1</u> NCR No. <u>16-6002</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>2016-07-29</u>		Step #: <u>105</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval DAS 9 9-89 <u>1608-03</u>		
Description Work Order Deviation				Disposition				Completed By	
Broken drill bit				Scrap and replace Qty 1 Batch # M134776				<u>16-08-02</u>	
								Lead hand / Supervisor Approval Verification DAS 14 9-89 <u>160802</u>	
								QC / QA Coordinator Approval DAS 9 9-89 <u>1608-03</u>	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☒ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☒ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐							
				OTHER :					

144614

Thursday, April 28, 2016 10:05:24 AM

N900040100

Setup Start *NS1*

Stop *NS2*

5

Cust Item ID:

Start Date: 4/27/2016 **Start Qty:** 5.00

5

Customer:

Required Date: 5/9/2016 **Req'd Qty:** 5.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.05

Quality Control

120

0.00

120

Mill Conv

Memo

0.00

Conventional Milling Machine

DRILL SIDE HOLES AS PER DWG

DEBURR

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.50

Quality Control

Picklist Print

Thursday, April 28, 2016 10:05:24 AM

Page 1

Work Order ID: 144614

144614

Parent Item: D4125-1

D4125-1

Parent Item Name: Fwd Sediment Bowl

Start Date: 4/27/2016

Required Date: 5/9/2016

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A 10.07.21 new issue DD verf:EC

IPP Rev:B 11/12/05 as per dwg. rev.B JFS verf:DD

15.03.04 remove alodine and add holes DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B2.000X08.00
0

Purchased

No

100

f

14.8950

1.115

5.868421

M6061T6B2 000X08 000

6061-T6 BAR 2.00' X 8.00" (CUT IN 4FT SECTION)

DAS
44
9-89

16-07-27

Location

Loc Qty

Loc Code

MAT007

14.895

m127095

0.596

• m132693

2.299

• m132772

4

m134495

8

134776

1.125

2.250

16-07-28

DART AEROSPACE LTD		Work Order: 14614
Description: Fwd Sediment Bowl		Part Number: D4125-1
Inspection Dwg: D4125	Rev: D	Page 1 of 1

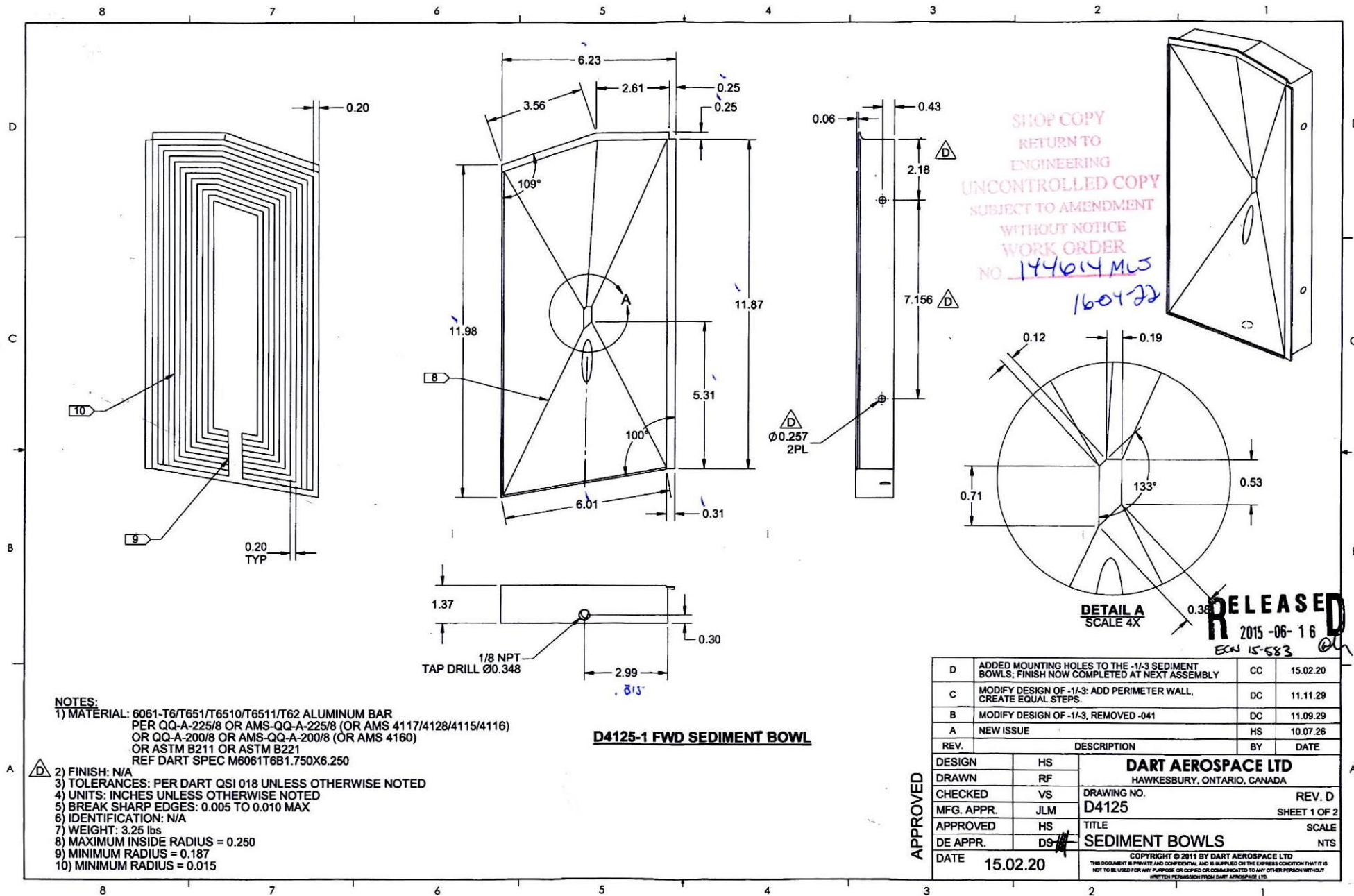
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.20	+/-0.030	.185				
6.23	+/-0.030	6.23				
3.56	+/-0.030	3.50				
2.61	+/-0.030	2.610				
0.25	+/-0.030	.250				
0.25	+/-0.030	.250				
11.87	+/-0.030	11.870				
0.31	+/-0.030	.320				
6.01	+/-0.030	6.020				
11.98	+/-0.030	11.990				
0.06	+/-0.030	.058				
1.37	+/-0.030	1.367				
2.99	+/-0.030	2.999				
0.30	+/-0.030	.298				
Ø0.348	+0.006/-0.001	.348				
2.18	+/- 0.010	2.184	✓		caliper	JCL 08
7.156	+/- 0.010	7.156	✓			
Ø 0.257	+0.005 -0.001	0.258	✓			
0.438	+/- 0.030	0.428	✓			

Measured by: DAS 32	Checked by: DAS 44	QC Inspector:
Date: 16-07-29	Date: 16-08-04	Date:

Engineering Approval: (If necessary)	Date:
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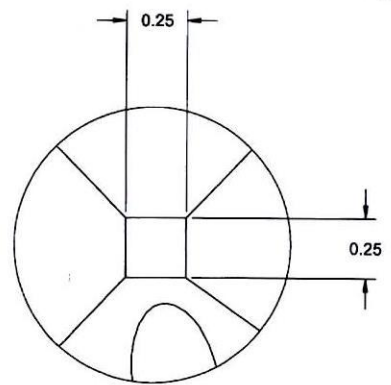
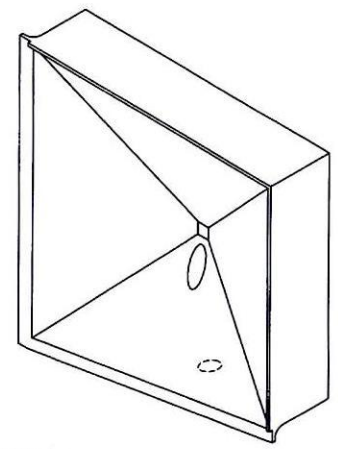
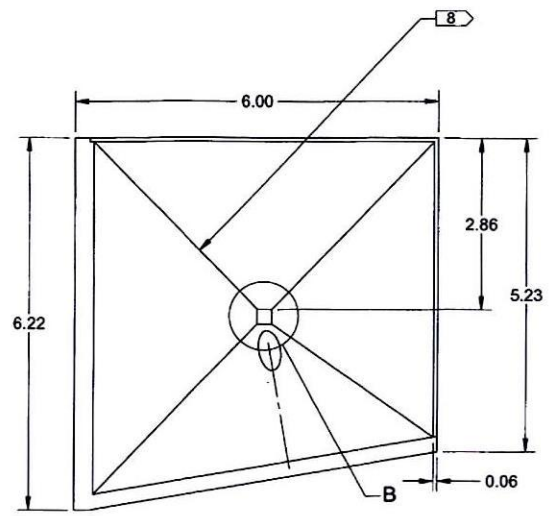
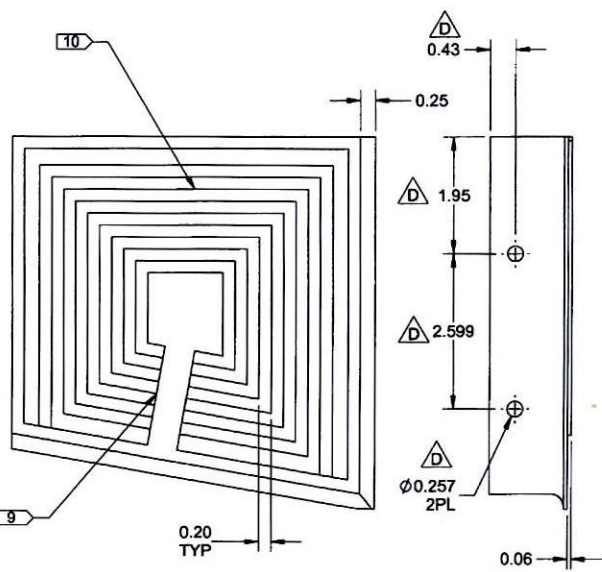
Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	
B	15.07.23	Dwg Rev updated	KJ	



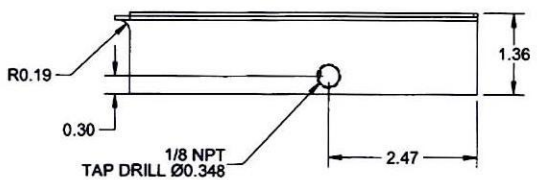
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



DETAIL B
SCALE 4X



D4125-3 AFT SEDIMENT BOWL

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B1.750X6.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.15 lbs
- 8) MAXIMUM INSIDE RADIUS = 0.250
- 9) MINIMUM RADIUS = 0.187
- 10) MINIMUM RADIUS = 0.015

RELEASED
2015-06-16

APPROVED	DESIGN	HS	DART AEROSPACE LTD	
	DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	VS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D4125	SHEET 2 OF 2
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	SEDIMENT BOWLS	NTS
	DATE	15.02.20		
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8 7 6 5 4 3 2 1